

Work Order ID 113126

February-12-14 8:37:12 AM

\*113126\*

Page 1

Item ID: D3456-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Washer  
 Start Date: 2/10/14 Start Qty: 24.00 Cust Item ID:  
 Required Date: 2/10/14 Req'd Qty: 24.00 Customer:  
 Reference:

Approvals: Process Plan: MLS Date: 1402-13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3456	Rev A

100 PURCHASING 0.00  
 \*100\* Purchasing Memo 0.00  
 Purchasing Issue P/O: 23067 P/N: 91525A120 per Dwg D3456Possible  
 Supplier: McMaster-CarrMaterial release note is required

CL 14/02/19 100

110 Receive & Inspect for Damage & Mat'l Certs 0.00  
 \*110\* Packaging Memo 0.00  
 Packaging Ensure Material Release Note is attached

14/14/21 (100)

120 QC6- Inspect dimensions to drawing 0.00  
 \*120\* QC Memo 0.00  
 Quality Control

DAS  
 27  
 9-89  
14/2/28

100

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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Work Order ID 113126

\*113126\*

Page 2

February-12-14 8:37:12 AM

Item ID: D3456-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Washer

Start Date: 2/10/14 Start Qty: 24.00

\*24\*

Cust Item ID:

Required Date: 2/10/14 Req'd Qty: 24.00

\*24\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: ST 046

0.00

\*130\*

Packaging

Memo

0.00

Packaging

100

DAS  
33  
9-89

14-02-21

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

0.00

Quality Control

14-02-24

14-02-24

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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### FAULT CATEGORY

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# Picklist Print

February-12-14 8:37:15 AM

Page 1

Work Order ID: 113126

\*113126\*

Parent Item: D3456-1

\*D3456-1\*

Parent Item Name: Washer

Start Date: 2/10/14

Required Date: 2/10/14

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP A05.10.03New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
91525A120		Purchased	No			100	Each	0.0000	1	24			
*91525A120*									**				
washer													

14/2/14 (100)

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

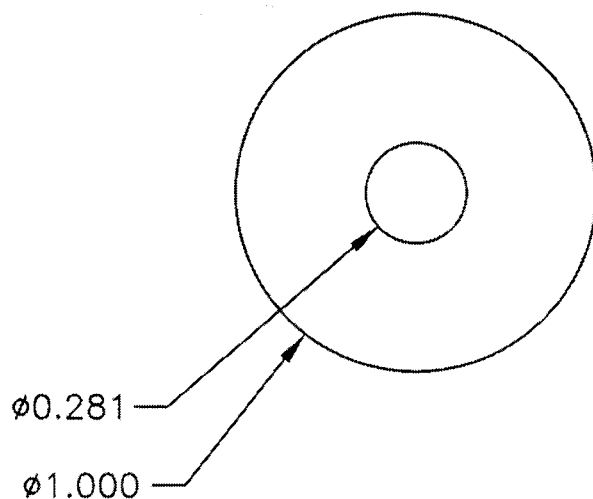
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DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3456	REV. A SHEET 1 OF 1
DATE 05.09.01		TITLE WASHER	SCALE 2:1
A	05.09.01	NEW ISSUE	

RELEASED  
05-09-06 [Signature]

## SPECIFICATION CONTROL DRAWING



### **D3456-1 WASHER**

- 1) MATERIAL: 316 STAINLESS STEEL, 0.050" THICK
- 2) MAY PURCHASE McMASTER-CARR P/N 91525A120
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

113126 MLC  
1402-13

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO23067

Purchase Order Date 2/19/2014

PO Print Date 2/19/2014

Page Number 1 of 5

Order From :  
MCMASTER-CARR SUPPLY CO,  
P.O. BOX 7690  
CHICAGO, IL 60680-7690  
US

VU-MCM001

Ship To : DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FAKED  
FG 1/2/19

Contact Name  
Vendor Phone 330 995 5500

Ship To Contact  
Ship To Phone

Ship Via FedEx PI collect  
Ship Acct

Buyer Chantal Lavoie  
Customer POID  
Customer Tax # 10127-2607  
Terms Net 10  
Currency USD  
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req. Qty/ Unit of Measure	PO Unit Price	Extended Price
1	91249A146  AS PER DWG D4898 REV. A B113458	Screw, Stainless Steel	2/20/2014 Yes 3/20/2014		100.00 Each	\$0.05	\$5.40
Line Total:							\$5.40
2	91525A120  AS PER DWG D3456 REV. A B113416  113126	washer	2/20/2014 Yes 3/20/2014		100.00 Each	\$0.27	\$26.64
Line Total:							\$26.64

PO Instructions: Procurement Quality Clauses  
A005 right of entry  
A026 certification of material conformance  
A040 notification of quality escape

Note:

2/19/2014

200 Aurora Industrial Pkwy  
Aurora OH 44202-8087  
330-995-5500  
cle.sales@mcmaster.comDart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
CanadaOrder Placed By  
**Chantal Lavoie**

02/19/2014

McMaster-Carr Number  
**8113645-02**

Line	Description	Ordered	Shipped
1	<b>91249A146</b> Black-Oxide Finish Pan Head Phillips Machine Screw, 18-8 Stainless Steel, 6-32 Thread, 3/8" Length, Packs of 100 Your Part Number: <b>B113458</b>	1 Pack	1
	Unit Price: \$5.40 Extended Price: \$5.40		
2	<b>91525A120</b> Type 316 Stainless Steel Large-Diameter Flat Washer, 1/4" Screw Size, 1" OD, .04"-.06" Thick, Packs of 25 Your Part Number: <b>B113216</b>	4 Packs	4
	Unit Price: \$6.66 Extended Price: \$26.64		
3	<b>97787A661</b> Expanding Diameter Quick-Release Pin, 1/4" Diameter, 1" Usable Length Your Part Number: <b>B113418</b>	30 Each	25
	Unit Price: \$114.68 Extended Price: \$2,867.00		
4	<b>92311A599</b> 18-8 Stainless Steel Cup Point Set Screw, 5/16"-24 Thread, 5/8" Long, Packs of 50 Your Part Number: <b>B113205</b>	4 Packs	4
	Unit Price: \$10.80 Extended Price: \$43.20		
5	<b>95606A170</b> Nylon 6/6 General Purpose Flat Washer, Off-White, 7/16" Screw Size, .69" OD, .02"-.04" Thickness, Packs of 100 Your Part Number: <b>B113164</b>	1 Pack	1
	Unit Price: \$10.14 Extended Price: \$10.14		
6	<b>98606A010</b> Alloy Steel Cup Point Set Screw Assortment, 200 Pieces, 12 Sizes in a Compartmented Plastic Box Your Part Number: <b>71500-30</b>	2 Each	2
	Unit Price: \$44.29 Extended Price: \$88.58		
7	<b>97395A452</b> Corrosion Resistant Dowel Pin, Type 316 Stainless Steel, 1/8" Diameter, 1" Length, Packs of 10 Your Part Number: <b>71500-30</b>	1 Pack	1
	Unit Price: \$9.79 Extended Price: \$9.79		
8	<b>5644K14</b> Assemble-Your-Own Retracting Air Hose, 5/16" ID, 3/8" OD, 210 PSI, Red, 100' Length Your Part Number: <b>71500-15</b>	1 Each	1
	Unit Price: \$74.74 Extended Price: \$74.74		
9	<b>5644K54</b> Brass Male 360 Degree Easy-Install Body for 5/16" ID, Assemble-Your-Own Retracting Air Hose Your Part Number: <b>71500-45</b>	20 Each	20
	Unit Price: \$7.80 Extended Price: \$156.00		